



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DT 8728

D2933-1

Job Sheet 179294



Part No: D2933-1

Job Qty: 4 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev: C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Machining-1		SBL 18/08/05
100	CNC Vertical Machining	4 pcs	6/29/18	6/29/18	0.40	5.92	HAAS1-2		SBL 18/08/05
110	Mill Conv	4 pcs	6/29/18	6/29/18	0.00	0.25	Mill Conv 1		SBL 18/08/05
120	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC1		SBL 18/08/05
130	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-1		2mm L 18/08/09
140	HandFinish	4 pcs	6/29/18	6/29/18	0.00	0.19	HandFinish1		DR 18/08/09
150	Powdercoat	4 pcs	6/29/18	6/29/18	0.00	0.14	Powdercoat1		18/08/10
160	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC3		38
170	Packaging	4 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1	5/376	AUG 2 2018
180	QC21-SA	4 Ea	6/29/18	6/29/18	0.00	0.00	QC21		AUG 2 4 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & Descriptions: attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA020.

150 - START TIME: 10:40am 10:30am 3200F

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S099254



Part: D2933-1

Job No: 179294

Serial No/Batch: S099254

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/03/18

DART AEROSPACE LTD				Work Order: 179294	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.126	.125	.125	.126	
B	0.100	0.140		.124	.123	.122	.124	
C	0.100	0.140		.110	.110	.110	.111	
D	0.210	0.230		.223	.222	.223	.223	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.510	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.257	.257	.257	.257	
L	0.312	0.317		.312	.312	.312	.312	
M	0.235	0.240		.239	.239	.239	.239	
N	0.100	0.140		.130	.130	.124	.123	
O	0.540	0.560		.550	.549	.549	.550	
P	0.490	0.510		.498	.498	.499	.499	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.493	2.490	2.490	2.492	
S	0.240	0.270		.250	.250	.255	.255	
T	0.100	0.180		.130	.140	.135	.140	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.125	1.145		1.135	1.135	1.135	1.135	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 57 18/08/04	Date:
Audited by: [Signature]	Date: 18/08/04
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DQA: _____ Date: _____

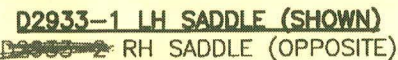


WORK ORDER NON-CONFORMANCE / UPDATE

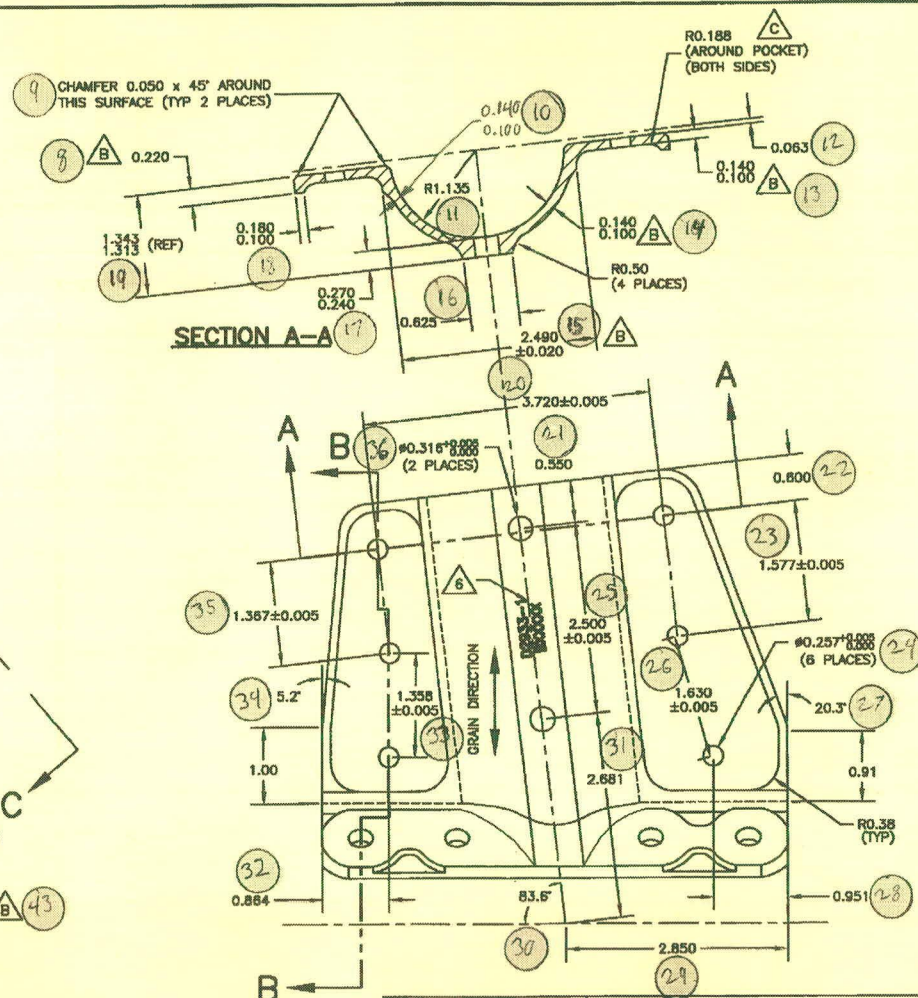
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : _____																																																																					



-
- Technical drawing of a mechanical part, Section B-B, showing a cross-section of a shaft with a keyway. The drawing includes dimensions for radii (R0.188, R0.50, R1.575, R0.025), diameters (0.063, 0.140, 0.100, 0.510, 0.500, 0.240, 0.235, 1.605), and angles (48.0 degrees). It also features callouts for material (SI 005 4.3), depth (5 DEEP), and various feature callouts (37, 39, 40, 41, 43, 44, 45, 46, 47) and section lines (A-A, B-B, C-C).



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. BELLEVUE, WA
#	CB	
CHECKED	APPROVED	DRAWING NO.
PH	#	D2933
DATE	TITLE	
06.11.09	SADDLE INSIDE	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
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Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				